

Work Order ID 82303

82303

Page 1

March-28-12 2:32:19 PM

Item ID: D3637-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 28/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLT Date: 12/03/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3637	Rev B								

100 FLOW WATER JET 0.00
100 Waterjet 10 0 Jun 12-6-25
 Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
304 .080 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 QC 10 0 Jun 12-6-25
 Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120 QC 5-2/00/24 40
 Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 28/03/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 11/04/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3637

140

0.00

140

Small Fab

0.00

Small Fab

Memo

Small Fab

1- drill holes as per dwg using DT89792-C'Sink as per Dwg D3637 3-
Install Nut plate as per Dwg D3637

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

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Work Order ID 82303***82303***

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March-28-12 2:32:19 PM

Item ID: D3637-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket Assembly

Stop

NS2

Start Date: 28/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location **ST 235A** 0.00***160***

Packaging

Memo

0.00

100

12-7-16

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

12/7/17

Quality Control

12-07-16

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NOTE: Date & initial all entries

Picklist Print

March-28-12 2:32:22 PM

Page 1

Work Order ID: 82303

82303

Parent Item: D3637-041

D3637-041

Parent Item Name: Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-3

Purchased

No

100

Each

4,223.000

2

20

MS20426AD3-3

Rivet

**

Location

Loc Qty

Loc Code

ST316

4223

119109

788

121011

3000

19099

435

M304S14GA

Purchased

No

140

sf

100.6000

0.09

0.947368

M304S14GA

304SS sheet .080

**

Location

Loc Qty

Loc Code

MAT020

100.6

117933

6.6

119276

94

MS21059L4

Purchased

No

140

Each

91.0000

1

10

MS21059L4

Nutplate

**

Location

Loc Qty

Loc Code

ST301

16

117887

3

119623

13

ST302

75

120930

25

121060

50

10

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Dart Aerospace Ltd

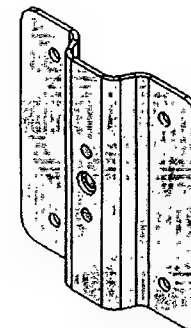
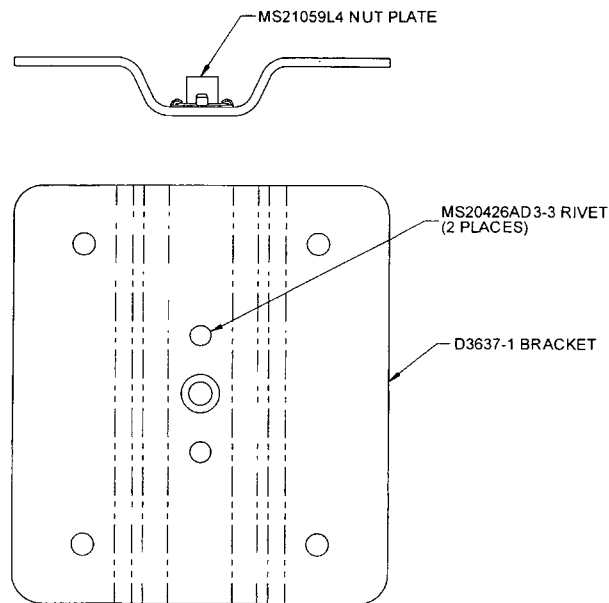
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82303 MLJ
12/03/28

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637 1 1 15 WAS 1 30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE, REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO	REV B
MFG APPR.	ME	D3637	SHEET 1 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	BRACKET	1:1
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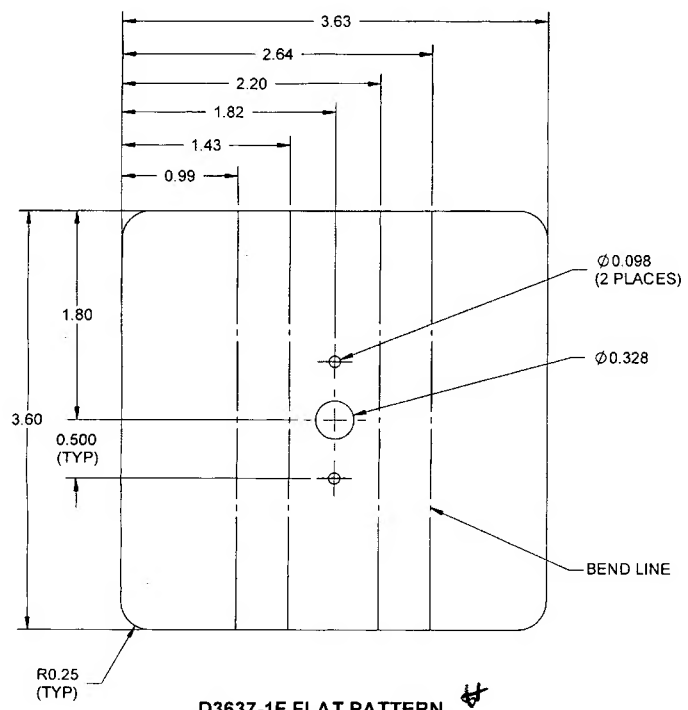
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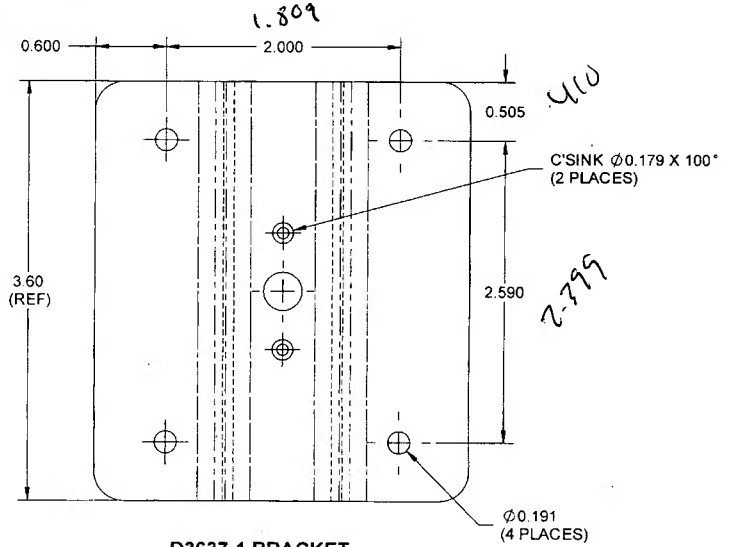
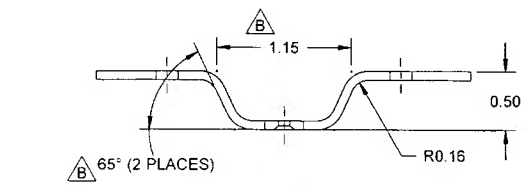
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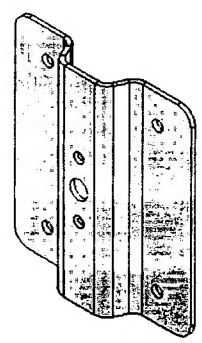
82303



D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



- D3637-1 NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	JS	D3637	SHEET 2 OF 3
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DE APPR.	JS	BRACKET	1:1
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RELEASED
08-02-03 7170

W/O:		WORK ORDER CHANGES					
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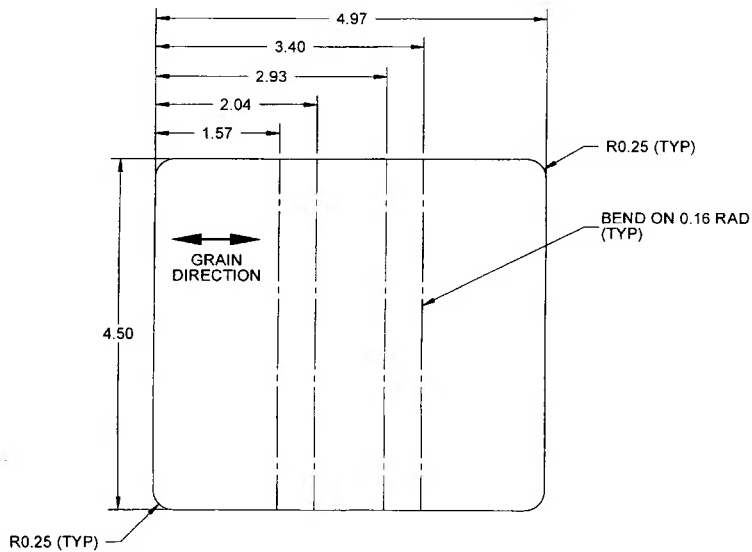
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

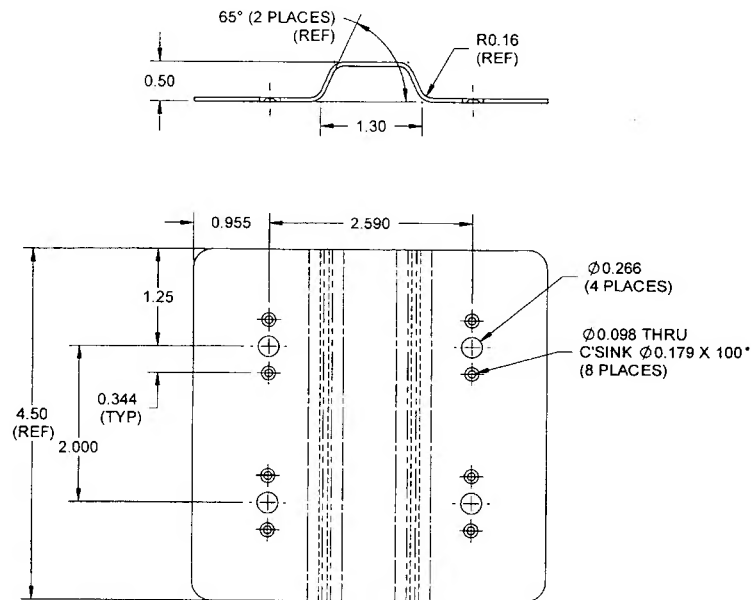
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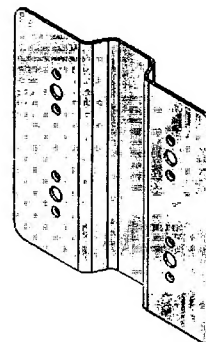
82303



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
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